

Date: Tuesday, 26/05/2009 12:47:51 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TAIL LIGHT FAIRING
Job Number : 48141	
Estimate Number : 12418	
P.O. Number :	Part Number : D3484042
This Issue : 26/05/2009 S.O. No. :	Drawing Number : D3484 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : LARGE FAB ASSY	Drawing Revision : F
Previous Run : 48141	Material :
Written By :	Due Date : 29/05/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 09.05.24</u>	
Comment : Est Rev:A New Issue 06-05-23 EC Est Rev:B 08-01-24 change rivet for CR1122-3-025 DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------



Comment: Issue P/O: 8863
 Make as per Dwg D3484
 Material release note is required

C809105/27

(10)

2.0	D3484042P	Tail Light Fairing Assembly, RH
-----	-----------	---------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Tail Light Fairing Assembly, RH

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

Pc 9/4/11 (10)

4.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------



Comment: VISUAL WELDING INSPECTION

PD 09.06.17

(PD)

5.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

S 09.06.17 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 26/05/2009 12:47:51 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 48141

Part Number: D3484042

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



X10

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

UMO 09/06/22

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



10

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 07-02-22

8.0

CR1122 3 025

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Rivet

Batch: M110849

MB 09-06-23

40x

9.0

MS2106904

ANCHOR NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

ANCHOR NUT

Batch: M111916

MB 09-06-23

20x

10.0

SMALL FAB-1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install Nut Plates as per Dwg D3484

MB 09-06-23

10x

11.0

QC5

INSPECT WORK TO CURRENT STEP



10x

Comment: INSPECT WORK TO CURRENT STEP

SO 09/06/23

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 2:30pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 3:00pm

MB 09-06-23

X10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 26/05/2009 12:47:51 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 48141

Part Number: D3484042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Q.m 09-06-23

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Identify on inside surface as indicated

TCCA-PDA,DART AEROSPACE LTD

P/N:D412-750-142 B/N:BXXXXX

FOR PRODUCT ELIGIBILITY SEE PDA06-13

5/20 3 09/06/24 (10)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/06/24 (10)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/24

Job Completion



h 09.06.24

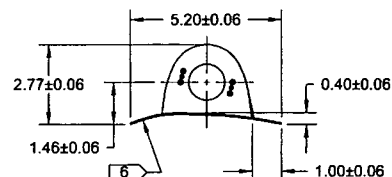
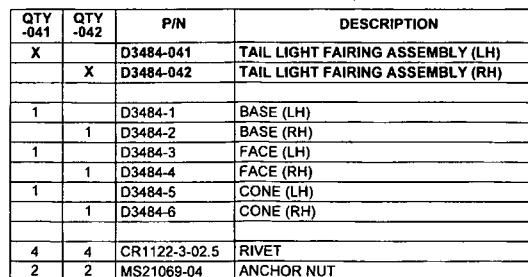
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

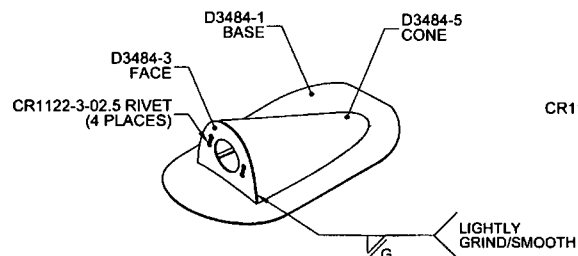
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

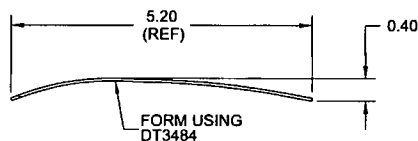
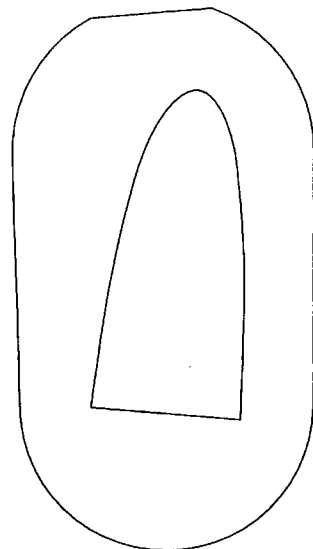
NOTE: Date & initial all entries



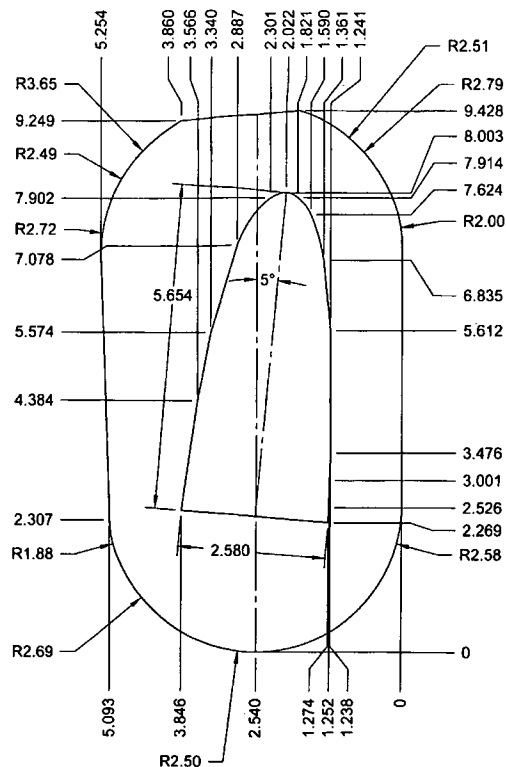
D3484-041 TAIL LIGHT FAIRING



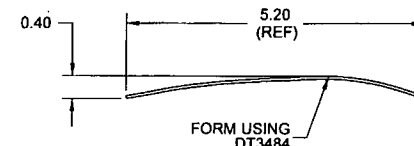
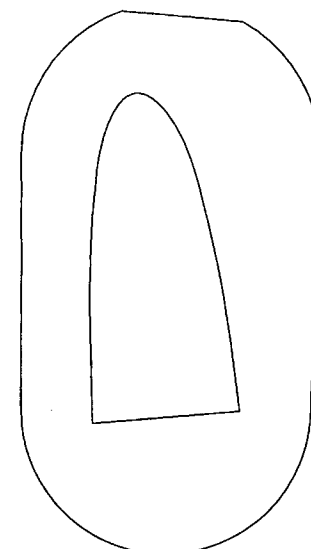
NOTES:



D3484-1 BASE
(MAKE FROM D3484-1F)



D3484-1F BASE FLAT PATTERN



D3484-2 BASE
(MAKE FROM D3484-1F)

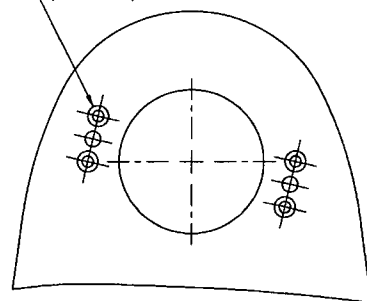
RELEASED
27/01/24

- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.16 lbs

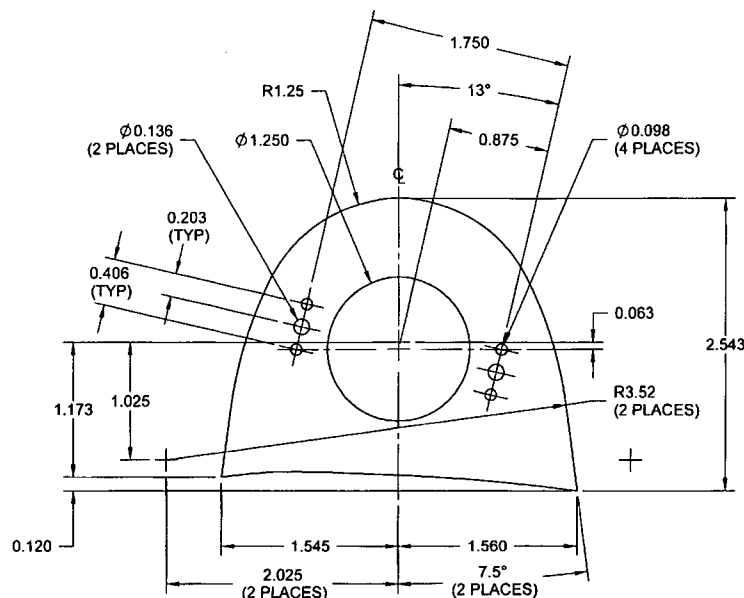
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3484	REV. F
MFG. APPR.		TITLE	SHEET 2 OF 4
APPROVED		TAIL LIGHT FAIRING	SCALE 1:2
DE APPR.		COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 48141
ENGINEERING
RETURN TO

C'SINK
Ø0.181 X 100°
(4 PLACES)

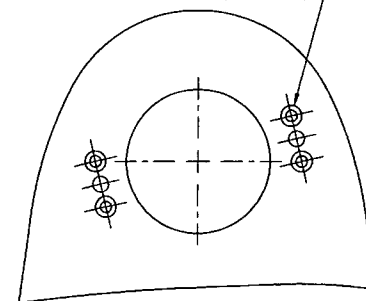


D3484-3 FACE
(MAKE FROM D3484-3F)



D3484-3F FLAT PATTERN TAIL LIGHT FAIRING

C'SINK
Ø0.181 X 100°
(4 PLACES)



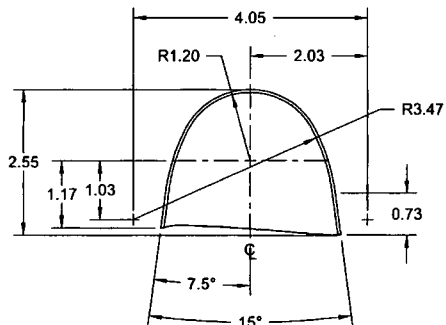
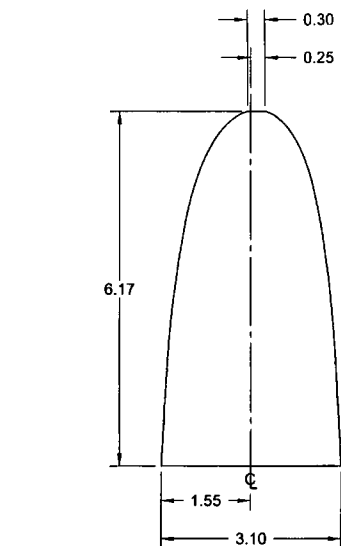
D3484-4 FACE
(MAKE FROM D3484-3F)

- NOTES:**
- 1) MATERIAL: 6061-O ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.02 lbs

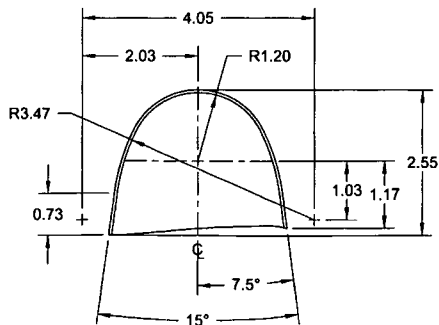
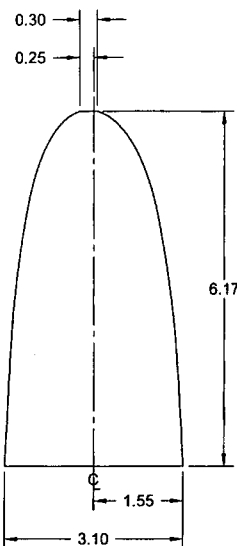
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09/03/31

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3484	REV. F
MFG. APPR.			SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TAIL LIGHT FAIRING	1:1
DATE	09.03.31	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO PARTS MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

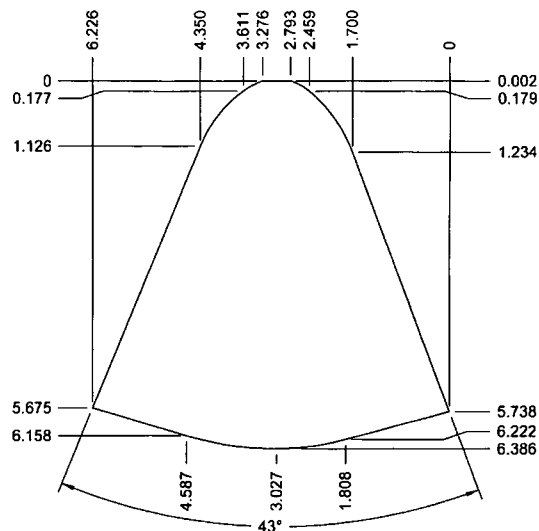
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WITHOUT NOTICE



D3484-5 CONE
(MAKE FROM D3484-5F)









D3484-6 CONE
(MAKE FROM D3484-5F)



D3484-5F CONE FLAT PATTERN

- NOTES:**
- 1) MATERIAL: 6061-O ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.11 lbs

RELEASED
09/04/04

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3484	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TAIL LIGHT FAIRING	1:2
DATE	09.03.31	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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WORK OR PART

NO 48171



180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI is a division of Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO
2009/06/11	0420165

EXPÉDIÉ À /

SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO.	N° COMMANDE PO NO.	VIA SHIP VIA
GFI-0299	J0201214	PO00008863	
VOTRE N° DE PIÈCE YOUR PART NO.		DESCRIPTION	
03484042P		TAIL LIGHT FAIRING CERTIFICATE OF CONFORMANCE REQ <i>8/6/18</i>	

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS À LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

RECU PAR / RECEIVED BY

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

6/10/09
S

CERTIFICATE NO. <u>2</u>		OUR JOB NO <u>J0201214</u>		SHIPPING MEMO <u>0420165</u>	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME
<u>--</u>	<u>10 PCS</u>	<u>PO00008863</u>	<u>D3484042P</u>	<u>F</u>	<u>TAIL LIGHT FAIRING</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.	
<u>AL 6061-T0 (QQ-A-250/11)</u>		<u>SAMUEL / ALCOA INC</u>		<u>564405</u>	

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 11 JUNE 2009

G.F.I. Q.C. REP.

Patton



Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTRE DE CONFORMITÉ --LETTER OF COMPLIANCE

Date: FEBRUARY 9, 2009

Company Name: GFI Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe-Claire Qc
Zip Code: H9R 1A1

du client: 0075178
Customer's order #:

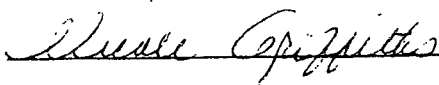
de commande SSMQ: 327150
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
1	1	.050" X 48" X 144"	6061-0	AMS 4025	564405

Bien à vous,
Yours truly,





Commis à l'administration.
Administration Clerk.

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Mark J. Vrabec

Mark J. Vrabec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

924669

Ship Date

2008-05-30

P.O. No./Govt Contract No.

N20720

0

B.L. No.

2963186

Invoice No.

00000

Customer

SAMUEL SON & CO LT DCE-43842-2

Ship From:

PITTSBURGH, PA

Alcoa No. Item

5043842-2

Mfg Order

Page

Ship To: SAMUEL SON & CO LTD
S.S.M.Q
21525 CLARKE-GRAHAM
BAIE D'URFE H9X 3TS QC

Item Description

0.05 IN TK (+0.0000 - .0035) X 48.0 IN W (+.125 -
.125) X 144.0 IN LN (+.15625 - .15625) (N) A/T 6061-
O FLAT SHEET FOR DISTRIBUTORS TOLERANCE GUARANTEED. AMS-QQ-A-
250/11 EXC_MRK AMS4025 REV K EXC_MRK
ASTMB209 REV 07 EXC_MRK CMMPO25 REV Q EXC_MRK
CMMPO19 REV D EXC_MRK CSTI008 REV D
((MARKED)) KRAFT PAPER INTERLEAVED
MAX GROSS SKID WGT: 6000 LB QUAN TOL +0
-30 % CQR 0216075 REV 01 CUST REQ 08-03-
01 *** W/E 08-04-05 ***

809/06/18

um	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
--	623928	564405	4317	132	PC	

Notes for CQR: 0216075.1

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/11 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/11F. PRODUCT
REDUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/11 F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/11.
Exception to Spec CMMPO25 ; Revsn: Q Issue: Letter dated 2004-08-24 from STEGEMANN, JEAN to BLACKIE, B.
Exception to Spec CMMPO19 ; Revsn: D Issue: Letter dated 2006-09-28 from AHERN, DENNIS T to BLACKIE, BILL
Exception to Spec CSTI008 ; Revsn: D Issue: Letter dated 2006-12-04 from AHERN, DENNIS T to BLACKIE, BILL

CQR: 0216075.1 -Specification Limits

	Dir	Max	Min	UTS KSI	TYS KSI	EL4D PCT
mp	Long Transv.			22.0	12.0	16
mp	Dir			UTS KSI	TYS KSI	EL4D PCT
42	Long Transv.			30.0	14.0	16
mp	Dir			UTS KSI	TYS KSI	EL4D PCT
62	Long Transv.			42.0	35.0	10



ERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA

DAVENPORT WORKS

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Mark J. Vrabec

Mark J. Vrabec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

924669

Ship Date

2008-05-30

P.O. No./Govt Contract No.

N20720

0

B.L. No.

2963186

Invoice No.

00000

Customer

SAMUEL SON & CO LT DCE-43842-2

Ship From:

PIEDMONT, IA.

Alcoa No. Item

5043842-2

Mfg Order

Page 2

QR: 0216075.1 -Specification Limits (cont.)

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total Aluminum
Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15
Min	0.40		0.15		0.8	0.04				REMAIN

Material: 564405 - Mechanical, Physical, Metallography, Quantometer Results

npr	Dir	No-> Test	UTS KSI	TYS KSI	EL4D PCT
12	Long Transv.	2	17.8	8	25.8
			18	7.8	24.8
12	Dir		UTS KSI	TYS KSI	EL4D PCT
	Long Transv.	2	36.5	18	23.3
			36.6	18.1	21.9
52	Dir		UTS KSI	TYS KSI	EL4D PCT
	Long Transv.	2	50.8	43.8	13.3
			50.7	43.7	13

Cast Number	Chemical	SI	FE	CU	MN	MG	CR	ZN	TI
3204064	Actuals	0.65	0.4	0.26	0.05	1.0	0.19	0.03	0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States